

Work Order ID 55928

February 4, 2010 2:41:40 PM



Page 1

Item ID: D350-636-011

Accept



Setup Start



Revision ID:

Stop



Item Name: Skidtube LH

Start Date: 2/04/10 Start Qty: 1.00



Cust Item ID:

Required Date: 2/12/10 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan:

RP

Date: 10-2-04 Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D2750

Rev F

100

0.00



DOCUMENT CONTROL

X

DC

Memo

0.00

Document Control

Photocopy blue file and type labels per PPP D350-636-011 CHG 005

8/10/03/03

B55928

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Approvals: Process Plan: Date: Tooling: Date:

Run Start

QC: Date: SPC (Y/N): Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

110

0.00



Skidtubes

Skidtubes

Memo

0.00

Skidtubes

1- Mark cut line on aft end of D2600-3-Bent using Jig DT 8150. Cut to length as per Dwg D2750. Deburr end

2-Drill pilot holes as per Dwg D2750 sheet 4 (D2750-1 details).Drill using drill Jig DT8150 & DT8863.

3- Mark fwd end for cutting using Drill Jig DT 8150 & DT8863 and cut as per dwg D2750.

4- drill pilot holes for blade fitting bolt holes using DT8983. Open to 0.500"

5- locate DT8330 off of blade fitting bolt holes and drill pilot holes for blade fitting

6-Open up holes for Detail B to 0.375" (4 holes per side)and blade fitting location holes to 0.500" (total of 4 holes per side) as per dwg D2750 .Open up holes for ground handling and detail C to 0.500" (8 holes per side)

7-Drill pilot holes for wearplates as per Dwg D2750 using DT8108 open to 0.297".

8-Open up holes of Detail A to 0.297" (total of 2 holes per side)

9-Weld D2744 Cap as per Dwg D2750 and QSI 004.Fill grooves in bend left from bending as per QSI 004
A/R ☐ ☐ Aluminum Rod

10-Grind welds flush as per Dwg D2750

110/2/8

3 BE 10/02/09

M1K320 7

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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NOTE: Date & initial all entries

Work Order ID 55928

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Item ID: D350-636-011

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Setup Start



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Item Name: Skidtube LH

Start Date: 2/04/10

Start Qty: 1.00



Cust Item ID:

Required Date: 2/12/10

Req'd Qty: 1.00



Customer:

Reference:

Run Start



Approvals:

Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

12- Scribe batch# inside per dwg D2750

11/01/2/8

120

QC10- Inspect visual per QSI004- ground welds

0.00



QC

Memo

0.00

Quality Control

130

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

140

Chemical Conversion Coat per QSI005 4.1

0.00



HandFinish

Memo

0.00

Hand Finishing

RE 10/02/09

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Approvals: Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

150

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

10-2-9

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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NOTE: Date & initial all entries

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Item ID: D350-636-011

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Setup Start



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Stop



Item Name: Skidtube LH

Start Date: 2/04/10 Start Qty: 1.00



Cust Item ID:

Required Date: 2/12/10 Req'd Qty: 1.00

Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160	Skidtubes	0.00							
	Skidtubes								
Skidtubes	Memo	0.00							
	1-Open up holes of Detail C and ground handling to 0.625" (total of 8 holes per side) as per dwg D2750.								
	2-Open up holes of Detail B to 0.750" (total of 4 holes per side) as per dwg D2750.								
	3- Open float hole to 0.500" (4 per side)								
	4-Chamfer holes of Detail B, C, ground handling and float holes per dwg D2750 (welding instructions on sheet 8)								
	5-Deburr and blow out all chips from inside of tube								
	6- Prepare tube for welding, remove alodine as required.								
	7-Bond web D2739 in place as per QSI 015 A/R <input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/> Sikaflex-291 batch: <u>M12429</u> <input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/> exp. date: <u>10/1/20</u>								
	8- Weld spacers D3490-1, D3490-3 and D2743 as per dwg D2750 & QSI004 (welding instructions on sheet 8) A/R <input type="checkbox"/> <input type="checkbox"/> Aluminum Rod batch: <u>M123207</u> <u>BE 10/02/10</u>								
	9-Grind welds flush as per Dwg D2750 <u>BE 10/02/11</u>								
	10-Spot face ground handling holes section (total of 4 places per side) as per dwg D2750								

BE 10/02/09

10/2/10

10-2-17

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Accept



Setup Start



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Stop



Item Name: Skidtube LH

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Cust Item ID:

Required Date: 2/12/10 Req'd Qty: 1.00



Customer:

Reference:

Run Start



Approvals: Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

11- At section AJ-AJ drill out x-bolt spacer to 0.404"

BE 10/02/11

12-Deburr holes

170



QC

Quality Control

QC10- Inspect visual per QSI004- ground welds

0.00

Memo

0.00

8/10/02/12

180



QC

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

Memo

0.00

8/10/02/12



W/O:		WORK ORDER CHANGES					
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NOTE: Date & initial all entries

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Setup Start

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Start Date: 2/04/10 Start Qty: 1.00

Cust Item ID:

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Customer:

Reference:

Run Start

Approvals: Process Plan:

Date:

Tooling:

Date:

Stop

QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

190

Pressure Wash per QSI005 4.3

0.00



HandFinish

Memo

Hand Finishing

DOCT - HALODIWEED

BR 10-02-18

D.

200

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

0.00



Powdercoat

Powder Coating

Memo

START TIME: *10:45AM*
OVEN TEMPERATURE: *320°F*
FINISH TIME: *11:15AM*

7 Feb 10/02/18

(X1)

G

210

QC3- Inspect Part Finish

0.00



QC

Quality Control

Memo

Inspect for foreign object per QSI 024

8/02/25

(40)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Work Order ID 55928

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Setup Start



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Item Name: Skidtube LH

Stop



Start Date: 2/04/10 Start Qty: 1.00



Cust Item ID:

Required Date: 2/12/10 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

220



HandFinish

Hand Finishing

HandFinishing

Memo

1- Install inserts as per Dwg D2750

0.00

0.00

MS

10/02/25

(X1)

Ø

230



HandFinish

Hand Finishing

HandFinishing

Memo

✓ 1-Inspect for Foreign Objects

✓ 2-Spray inside of tube with "LPS-3" batch: N/A

✓ 3-Install blade fitting D3488-041, wearshoes and ground handling hardware as per dwg D2750
SIKA FLEX 241
BATCH: M112345
EXP DATE: 10/08

✓ 4-assemble o'ring to plug as per dwg D3492 and apply o'ring lube
A/R 55-o'ring lube batch: M101223

✓ 5-Coat all exposed fasteners with "LPS Procyon" batch: M104256

0.00

0.00

MS 10/02/26

(X1)

Ø

Work Order ID 55928

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Item ID: D350-636-011

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Setup Start



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Item Name: Skidtube LH

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Cust Item ID:

Required Date: 2/12/10 Req'd Qty: 1.00



Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

240

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

8/10/02/02

(K)

250

Pick Kit

0.00



Packaging

Memo

0.00

Packaging

10-3-2 sf

260

QC4- 100% Inspect kits for completeness

0.00



QC

Memo

0.00

Quality Control

8/10/03/03

(K)

*****ensure antiseize is on AN8C21A bolts*****

Work Order ID 55928

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Item ID: D350-636-011

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Setup Start



Revision ID:

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Customer:

Reference:

Run Start



Approvals: Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

270



Packaging

Packaging

0.00

0.00

Memo

Package as per PPP D350-636-011

Rev H

10-3-4 SF

280



QC

Quality Control

QC21- Final Inspection - Work Order Release

0.00

0.00

Memo

10603605 J
ME 10-3-4

Picklist Print

February 4, 2010 2:40:54 PM

Page 1

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Work Order ID: 55928



Parent Item: D350-636-011



Parent Item Name: Skidtube LH

Start Date: 2/04/10

Required Date: 2/12/10

Comments: IPP Rev: I 02.09.25 Rearranged procedure steps [KJ]
 IPP Rev: J 06-03-23 As per Rev D JLM
 IPP Rev: K 06-07.13 As per dsi9343 EC
 IPP Rev: L 07-07-28 Added SS Wearplates (Rev E) JLM Verified By: EC

Start Qty: 1.00

Required Qty: 1.00

D2594-3 Manufactured No 230 Each 700.0000 8.0000



O-Ring, 205 Skidtube

Warehouse Loc Qty Loc Code

Location

Main Warehouse

FP 527

51613 27

55546 500

Main Warehouse

ST 173

52562 173

X8 10/02/25

D2744 Manufactured No 110 Each 51.0000 1.0000



Cap

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST 51

44892 1

47488 23

51922 27

1 10/02/09

W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Picklist Print

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Parent Item Name: Skidtube LH

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 IPP Rev: J 06-03-23 As per Rev D JLM
 IPP Rev: K 06-07.13 As per dsi9343 EC
 IPP Rev: L 07-07-28 Added SS Wearplates (Rev E) JLM Verified By: EC

Start Qty: 1.00

Required Qty: 1.00

D2600-3-BENT

Manufactured No

110

Each

17.0000

1.0000



Extrusion Bent

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
LG	12	
50675	2	
55462	10	
Main Warehouse		
ST	5	
43495	1	
47133	1	
52346	3	

110/218

D2743

Manufactured No

160

Each

227.0000

8.0000



Crossbolt Spacer

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
LG	52	
50281	50	
51913	2	
Main Warehouse		
ST	175	
44891	2	
45555	17	
48275	1	
52310	155	

8 DE 10/02/10

February 4, 2010 2:40:55 PM

Shop Packet Print

Page 2

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Picklist Print

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Required Date: 2/12/10

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 IPP Rev: J 06-03-23 As per Rev D JLM
 IPP Rev: K 06-07.13 As per dsi9343 EC
 IPP Rev: L 07-07-28 Added SS Wearplates (Rev E) JLM Verified By: EC

Start Qty: 1.00

Required Qty: 1.00

D2739 Manufactured No 160 Each 5.0000 1.0000



350 I Beam

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

5

47124

1

53900

2

55034

1

55569

1

B55 986

1 11/10/2/9

D3490-3 Manufactured No 160 Each 69.0000 4.0000



Cross Bolt Spacer

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

LG

60

55010

60

Main Warehouse

ST

9

45560

1

48276

4

51930

4

4 BE 10/02/10

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Shop Packet Print

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 IPP Rev: J 06-03-23 As per Rev D JLM
 IPP Rev: K 06-07.13 As per dsi9343 EC
 IPP Rev: L 07-07-28 Added SS Wearplates(Rev E) JLM Verified By: EC

Start Qty: 1.00

Required Qty: 1.00

D3490-1 Manufactured No 160 Each 52.0000 4.0000



Cross Bolt Spacer

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST	52
45338	2
47657	2
48277	9
51932	39

ALS4-1032-225 Purchased No 220 Each 6,420.000 38.0000



Insert

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST	6420
107441	16
110768	6404

4 BE 10/02/10

38 41 10/02/25

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Shop Packet Print

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W/O:		WORK ORDER CHANGES					
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 IPP Rev: L 07-07-28 Added SS Wearplates (Rev E) JLM Verified By: EC

Start Qty: 1.00

Required Qty: 1.00

D3492-041 Manufactured No 230 Each 121.0000 8.0000



Plug Assembly

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
ST	121	
51584	44	
55446	77	

X8 MA 10/02/25

D3793-3 Manufactured No 230 Each 10.0000 1.0000



Wearshoe

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
ST	10	
51592	10	

X1 MA 10/02/25

AN8C35A Purchased No 230 Each 131.0000 1.0000



BOLT

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
ST	131	
102180	1	
106896	1	
110105	48	
110847	81	

X1 MA 10/02/25

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Page 5

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Work Order ID: 55928



Parent Item: D350-636-011



Parent Item Name: Skidtube LH

Start Date: 2/04/10

Required Date: 2/12/10

Comments: IPP Rev: I 02.09.25 Rearranged procedure steps LKJ
 IPP Rev: J 06-03-23 As per Rev D JLM
 IPP Rev: K 06-07.13 As per dsi9343 EC
 IPP Rev: L 07-07-28 Added SS Wearplates (Rev E) JLM Verified By: EC

Start Qty: 1.00

Required Qty: 1.00

D3793-1 Manufactured No 230 Each 15.0000 1.0000



Wearshoe

Warehouse Loc Qty Loc Code
Location

Main Warehouse

ST 15

40551 1

51597 14

D3488-041 Manufactured No 230 Each 11.0000 1.0000



Blade Fitting Assembly, LH

Warehouse Loc Qty Loc Code
Location

Main Warehouse

ST 11

47348 11

xl 11 10/02/25

xl 11 10/02/25

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Page 6

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Page 7

Work Order ID: 55928



Parent Item: D350-636-011



Parent Item Name: Skidtube LH

Start Date: 2/04/10

Required Date: 2/12/10

Comments: IPP Rev: I 02.09.25 Rearranged procedure steps KJ
IPP Rev: J 06-03-23 As per Rev D JLM
IPP Rev: K 06-07.13 As per dsi9343 EC
IPP Rev: L 07-07-28 Added SS Wearplates(Rev E) JLM Verified By: EC

Start Qty: 1.00

Required Qty: 1.00

D3794-3

Manufactured No

230

Each

15.0000

1.0000



Gasket

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

FP

356066

x1 44 10/02/25

51598

12

2

51907

10

Main Warehouse

ST

3

46531

2

47440

1

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

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Page 8

Work Order ID: 55928



Parent Item: D350-636-011



Parent Item Name: Skidtube LH

Start Date: 2/04/10

Required Date: 2/12/10

Comments: IPP Rev: I 02.09.25 Rearranged procedure steps [KJ]
 IPP Rev: J 06-03-23 As per Rev D JLM
 IPP Rev: K 06-07.13 As per dsi9343 EC
 IPP Rev: L 07-07-28 Added SS Wearplates (Rev E) JLM Verified By: EC

Start Qty: 1.00

Required Qty: 1.00

AN6C44A Purchased No 230 Each 116.0000 4.0000



BOLT

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
OFFSHORE		
FG	2	
103964	2	
Main Warehouse		
ST	114	
110105	4	
110155	14	
110665	1	
11605	42	
111649	50	
112720	1	
113121	2	

XL 10/02/25

MS21083C8 Purchased No 230 Each 78.0000 1.0000



NUT

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
ST	78	
110584	5	
111424	2	
13149	21	
113845	50	

XL 10/02/25

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

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Work Order ID: 55928



Parent Item: D350-636-011



Parent Item Name: Skidtube LH

Start Date: 2/04/10

Required Date: 2/12/10

Comments: IPP Rev: I 102.09.25 [] Rearranged procedure steps [] KJ []
IPP Rev: J 06-03-23 As per Rev D JLM
IPP Rev: K 06-07-13 As per dsi9343 EC
IPP Rev: L 07-07-28 Added SS Wearplates (Rev E) JLM Verified By: EC

Start Qty: 1.00

Required Qty: 1.00

D3536-25 Manufactured No 230 Each 33.0000 1.0000



Gasket

Warehouse Loc Qty Loc Code

Location

Main Warehouse

FP10 28

51607 2

54479 26

Main Warehouse

ST 5

45569 1

47011 2

47526 2

x1 JH 10/02/25

D3631-1 Manufactured No 230 Each 394.0000 8.0000



Washer

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST 394

52693 94

54388 300

x8 JH 10/02/25

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

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Work Order ID: 55928



Parent Item: D350-636-011



Parent Item Name: Skidtube LH

Start Date: 2/04/10

Required Date: 2/12/10

Comments: IPP Rev: I 02.09.25 Rearranged procedure steps LKJ
 IPP Rev: J 06-03-23 As per Rev D JLM
 IPP Rev: K 06-07-13 As per dsi9343 EC
 IPP Rev: L 07-07-28 Added SS Wearplates (Rev E) JLM Verified By: EC

Start Qty: 1.00

Required Qty: 1.00

D3791-1 Manufactured No 230 Each 5.0000 1.0000



Wearplate

Warehouse Loc Qty Loc Code

Location

Main Warehouse

FP 2

51610 2

Main Warehouse

ST 3

(51909) 3

AN960C10L Purchased No 230 Each 388.0000 38.0000



washer

NA51149C0332R

Warehouse Loc Qty Loc Code

Location

OFFSHORE

FG 100

103585 100

Main Warehouse

ST 288

112116 128

112612 160

M113737

X38 JH 10/02/25

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Work Order ID: 55928



Parent Item: D350-636-011



Parent Item Name: Skidtube LH

Start Date: 2/04/10

Required Date: 2/12/10

Comments: IPP Rev: I 02.09.25 [Rearranged procedure steps] [KJ]
IPP Rev: J 06-03-23 As per Rev D JLM
IPP Rev: K 06-07-13 As per dsi9343 EC
IPP Rev: L 07-07-28 Added SS Wearplates(Rev E) JLM Verified By: EC

Start Qty: 1.00

Required Qty: 1.00

D2745

Manufactured No

230

Each

298.0000 8.0000



Bushing

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST 36

43754 2

44893 33

45556 1

Main Warehouse

ST023 23

34817 2

36230 8

37303 1

39587 2

40726 2

41114 2

42778 6

Main Warehouse

ST46 239

51537 54

51910 4

52311 181

x8 10/02/25

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Work Order ID: 55928

Parent Item: D350-636-011

Parent Item Name: Skidtube LH

Start Date: 2/04/10

Required Date: 2/12/10

Comments: IPP Rev: I 02.09.25 Rearranged procedure steps [1KJ]
 IPP Rev: J 06-03-23 As per Rev D JLM
 IPP Rev: K 06-07.13 As per dsi9343 EC
 IPP Rev: L 07-07-28 Added SS Wearplates(Rev E) JLM Verified By: EC

Start Qty: 1.00

Required Qty: 1.00

AN3C5A Purchased No 230 Each 706.0000 34.0000



Bolt

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
ST	706	
111424	8	
111707	69	
112314	1	
113121	214	
113149	300	
113644	114	

X 34 24 10/02/25

D3537-1 Manufactured No 230 Each 90.0000 3.0000



Wearpad

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
FP	2	
48288	2	
Main Warehouse		
FP17	88	
51678	1	
51679	87	

X 3 24 10/02/25

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Work Order ID: 55928



Parent Item: D350-636-011



Parent Item Name: Skidtube LH

Start Date: 2/04/10

Required Date: 2/12/10

Comments: IPP Rev: I 02.09.25 Rearranged procedure steps KJ
 IPP Rev: J 06-03-23 As per Rev D JLM
 IPP Rev: K 06-07.13 As per dsi9343 EC
 IPP Rev: L 07-07-28 Added SS Wearplates(Rev E) JLM Verified By: EC

Start Qty: 1.00

Required Qty: 1.00

AN960C816L

Purchased No

230

Each

216.0000

1.0000



WASHER

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

216

104093

2

107520

4

110139

29

110584

100

111424

81

D3492-043

Manufactured No

230

Each

95.0000

8.0000



Plug Assembly

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

FP

91

54682

91

Main Warehouse

ST

4

52309

4

X1 21 10/02/25

X8 21 10/02/25

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Work Order ID: 55928



Parent Item: D350-636-011



Parent Item Name: Skidtube LH

Start Date: 2/04/10

Required Date: 2/12/10

Comments: IPP Rev: I 02.09.25 Rearranged procedure steps! KJ
 IPP Rev: J 06-03-23 As per Rev D JLM
 IPP Rev: K 06-07.13 As per dsi9343 EC
 IPP Rev: L 07-07-28 Added SS Wearplates(Rev E) JLM Verified By: EC

Start Qty: 1.00

Required Qty: 1.00

AN3C6A Purchased No 230 Each 778.0000 4.0000



BOLT

Warehouse Loc Qty Loc Code
Location

Main Warehouse

ST

778

111982

778

24 24 10/02/25

NAS1611-013 Purchased No 230 Each 142.0000 8.0000



O-RING

Warehouse Loc Qty Loc Code
Location

Main Warehouse

FP

100

113743

100

Main Warehouse

ST

42

106513

11

111424

20

111758

11

18 24 10/02/25

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Work Order ID: 55928

Parent Item: D350-636-011

Parent Item Name: Skidtube LH

Start Date: 2/04/10

Required Date: 2/12/10

Comments: IPP Rev: I 02.09.25 [Rearranged procedure steps [KJ]]
 IPP Rev: J 06-03-23 As per Rev D JLM
 IPP Rev: K 06-07.13 As per dsi9343 EC
 IPP Rev: L 07-07-28 Added SS Wearplates (Rev E) JLM Verified By: EC

Start Qty: 1.00

Required Qty: 1.00

D3535-25 Manufactured No 230 Each 8.0000 1.0000



Wearshoe

Warehouse Loc Qty Loc Code

Location

Main Warehouse

FP

2

51927

2

Main Warehouse

ST

6

52589

6

D3794-1 Manufactured No 230 Each 21.0000 1.0000



Gasket

Warehouse Loc Qty Loc Code

Location

Main Warehouse

FP

18

51928

6

55459

12

Main Warehouse

ST

3

46530

1

47212

2

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

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Work Order ID: 55928



Parent Item: D350-636-011



Parent Item Name: Skidtube LH

Start Date: 2/04/10

Required Date: 2/12/10

Comments: IPP Rev: I 02.09.25 Rearranged procedure steps [KJ]
 IPP Rev: J 06-03-23 As per Rev D JLM
 IPP Rev: K 06-07-13 As per dsi9343 EC
 IPP Rev: L 07-07-28 Added SS Wearplates (Rev E) JLM Verified By: EC

Start Qty: 1.00

Required Qty: 1.00

MS21043-6 Purchased No 230 Each 976.0000 4.0000



NUT

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST 976

112314 976

Manufactured No 260 Each 41.0000 2.0000

D3493-1



Washer

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST 41

44902 2

47710 39

Purchased No 260 Each 78.0000 2.0000

MS21083C8



NUT

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST 78

110584 5

111424 2

113149 21

113845 50

44 10/02/26
SP

10-32 SP

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Work Order ID: 55928



Parent Item: D350-636-011



Parent Item Name: Skidtube LH

Start Date: 2/04/10

Required Date: 2/12/10

Comments: IPP Rev: I 02.09.25 Rearranged procedure steps KJ
 IPP Rev: J 06-03-23 As per Rev D JLM
 IPP Rev: K 06-07.13 As per dsi9343 EC
 IPP Rev: L 07-07-28 Added SS Wearplates(Rev E) JLM Verified By: EC

Start Qty: 1.00

Required Qty: 1.00

8

AN8C21A

Purchased

No

260

Each

130.0000

2.0000



BOLT

10-3-23

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

130

105160

1

107596

1

107924

2

109092

2

110341

2

110342

2

111605

50

112720

20

113558

50

2

8

AN960C816L

Purchased

No

260

Each

216.0000

2.0000



WASHER

10-3-2 SU

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

216

104093

2

107520

4

110139

29

110584

100

111424

81

2

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

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Work Order ID: 55928



Parent Item: D350-636-011



Parent Item Name: Skidtube LH

Start Date: 2/04/10

Required Date: 2/12/10

Comments: IPP Rev: I 02.09.25 Rearranged procedure steps [KJ]
 IPP Rev: J 06-03-23 As per Rev D JLM
 IPP Rev: K 06-07.13 As per dsi9343 EC
 IPP Rev: L 07-07-28 Added SS Wearplates (Rev E) JLM Verified By: EC

Start Qty: 1.00

Required Qty: 1.00

D3672-1

Manufactured No

230

Each

1,720.000 4.0000



Phenolic Washer

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST

1220

39275

19

42329

5

47628

196

52505

1000

Main Warehouse

ST117

500

51674

500

x4 24 1010226

D2741

Manufactured No

260

Each

24.0000 1.0000



Blade, 350 Skidtube

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST

24

51931

24

10-3-2 SP

+

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

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Work Order ID: 55928



Parent Item: D350-636-011



Parent Item Name: Skidtube LH

Start Date: 2/04/10

Required Date: 2/12/10

Comments: IPP Rev: I 02.09.25 [Rearranged procedure steps] KJ
 IPP Rev: J 06-03-23 As per Rev D JLM
 IPP Rev: K 06-07.13 As per dsi9343 EC
 IPP Rev: L 07-07-28 Added SS Wearplates(Rev E) JLM Verified By: EC

Start Qty: 1.00

Required Qty: 1.00

D3532-1

Manufactured No

260

Each

68.0000

2.0000



Spacer

103-25

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

68

44904

2

52321

66

2

D3672-13

Purchased

No

260

Each

934.0000

2.0000



Phenolic Washer

103-2

5

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

934

54363

934

2

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

QTY -041	QTY -042	QTY -043	QTY -044	PART NUMBER	DESCRIPTION
X				D2750-041	350 SKIDTUBE ASSEMBLY, LH
	X			D2750-042	350 SKIDTUBE ASSEMBLY, RH
		X		D2750-043	350 SKIDTUBE ASSEMBLY, LH
			X	D2750-044	350 SKIDTUBE ASSEMBLY, RH
1	1	1	1	D2739	WEB
8	8	8	8	D2743	SPACER
1	1	1	1	D2744	CAP
8	8	8	8	D2745	BUSHING
1				D2750-1	SKIDTUBE WELDMENT, LH
	1			D2750-2	SKIDTUBE WELDMENT, RH
		1		D2750-3	SKIDTUBE WELDMENT, LH
			1	D2750-4	SKIDTUBE WELDMENT, RH
1		1		D3488-041	BLADE FITTING, LH
	1		1	D3488-042	BLADE FITTING, RH
4	4	4	4	D3490-1	SPACER
4	4			D3490-3	SPACER
		4	4	D3490-5	SPACER
8	8	8	8	D3492-041	PLUG ASSEMBLY
8	8			D3492-043	PLUG ASSEMBLY
		8	8	D3492-045	PLUG ASSEMBLY
1	1	1	1	D3535-25	WEARSHOE
1	1	1	1	D3536-25	GASKET
3	3	3	3	D3537-1	WEARPAD
8	8	8	8	D3631-1	WASHER
1	1	1	1	D3791-1	WEARPLATE
1	1	1	1	D3793-1	WEARSHOE
1	1	1	1	D3793-3	WEARSHOE
1	1	1	1	D3794-1	GASKET
1	1	1	1	D3794-3	GASKET
38	38	38	38	ALS4-1032-225	INSERT (OR ALS7-1032-225, AKS4-1032-225, AELS-1032-225)
34	34	34	34	AN3C5A	BOLT
4	4	4	4	AN3C6A	BOLT
4	4	4	4	AN6C44A	BOLT
1	1	1	1	AN8C35A	BOLT
38	38	38	38	AN960C10L	WASHER
1	1	1	1	AN960C816L	WASHER
4	4	4	4	MS21043-5	NUT
1	1	1	1	MS21083C8	NUT
4	4	4	4	NAS1515H3L	WASHER

GENERAL NOTES:

- MATERIAL: MAKE D2750-1/-2/-3/-4 FROM D2600-3 EXTRUSION (INITIAL LENGTH = 120.0).
- FINISH:
ACID ETCH, ALONDE ASSEMBLY PER DART QSI 005 4.1 PRIOR TO INSTALLING D2739 WEB.
POWDER COAT WHITE (REF. 4.3.5.1) PER DART QSI 005 4.3
BLACK ANTI-SKID PAINT AS INDICATED TO 1.0 ABOVE SKIDTUBE CENTER-LINE PER DART 005 4.4 (OPTIONAL).
- TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- UNITS: INCHES UNLESS OTHERWISE NOTED
- BREAK SHARP EDGES: N/A
- IDENTIFICATION: N/A
- WEIGHT: D2750-041/-042/-043/-044 = 26.5 LBS
- WELD PER DART QSI 004
- INSTALL ALS4-1032-225 INSERTS AFTER FINISH AS INDICATED. DRILL 'F' SIZE HOLES ($\phi 0.297$) FOR WEARSHOE INSERTS
- FINAL CONFIGURATION SHOULD HAVE THE FOLLOWING MINIMUM MECHANICAL PROPERTIES:
MINIMUM YIELD TENSILE STRENGTH = 35 KSI
MINIMUM ULTIMATE TENSILE STRENGTH = 38 KSI
- SPRAY INSIDE OF TUBE WITH A COAT OF LPS LABORATORIES "LPS-3" AFTER FINISH AND AFTER INSTALLATION OF INSERTS.
COAT ALL EXPOSED FASTENERS WITH LPS LABORATORIES "LPS PROCYON" AFTER FINAL ASSEMBLY, CLEAN EXCESS OFF
POWDER COATING WITH MEK DEGREASER.
- SPACER AND PLUG INSTALLED SAME AS SECTION AJ-AJ EXCEPT HORIZONTAL
- SPACER AND PLUG INSTALLED SAME AS SECTION AP-AP EXCEPT HORIZONTAL

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WITHOUT NOTICE

WORK ORDER

NO. 55928

10-2-04

RELEASED

F	INCORPORATE DSI 9413; QTY (3) D3537-1 WAS QTY (5) (ZN C8-1); D3791-1/3 REPLACES D3535-13/35 (ZN C8-1); D3794-1/3 REPLACES D3536-13/35 (ZN B8-1); ADD D3791-1 (ZN C8-1); WEARSHOE HOLES UNDER FWD/AFT SADDLE REMOVED (8 PL). WEARSHOE HARDWARE QTY UPDATED (ZN B8-1); D3488-041/042 HARDWARE UPDATED (ZN C1-8, 9, 10, 11); ADD NOTE 12 AND 13 (ZN A6-1); REASON: REF. NCR 08-043	PH	08.07.16
E	CHANGE TO STAINLESS STEEL WEARPLATES; ADD RUBBER GASKETS, CHANGE INSERTS; ADD D3631-1; REMOVE QTY (38) NAS1515H3L; REMOVE QTY (10) NAS1515H8L, REMOVE D2741; QTY (2) AN960C816; REMOVE QTY (2) MS21083C8	CB	07.05.17
D	ADD HOLES AND SPACERS FOR APICAL FLOATS; INCORPORATE DEO 9133/9157	PH	06.01.05
C	ADD D2750-3/D2750-4; INCORPORATE D2738 AND D2740	CP	98.11.18
B	CHANGE MS24694-S293 TO AN8-16A	CP	98.09.01
A	NEW ISSUE	DS	98.04.16
REV.	DESCRIPTION	BY	DATE
DESIGN	<i>RL</i>	DART AEROSPACE USA, INC.	
DRAWN	<i>RL</i>	PORT HADLOCK, WA	
CHECKED	<i>RL</i>	DRAWING NO.	REV. F
MFG. APPR.	<i>RL</i>	D2750	SHEET 1 OF 11
APPROVED	<i>RL</i>	TITLE	SCALE
DE APPR.	<i>RL</i>	350 SKIDTUBE ASSEMBLY	NTS
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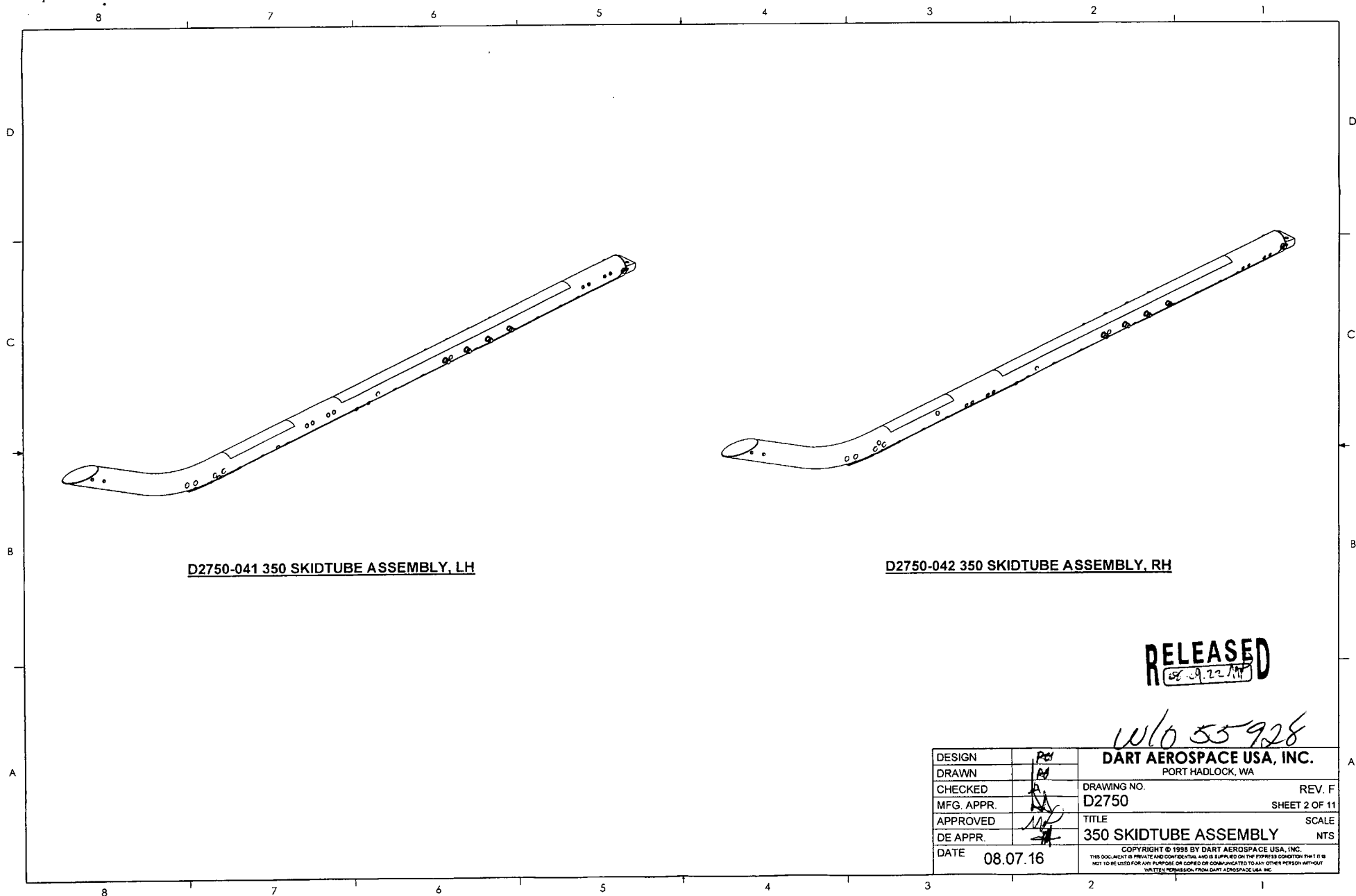
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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



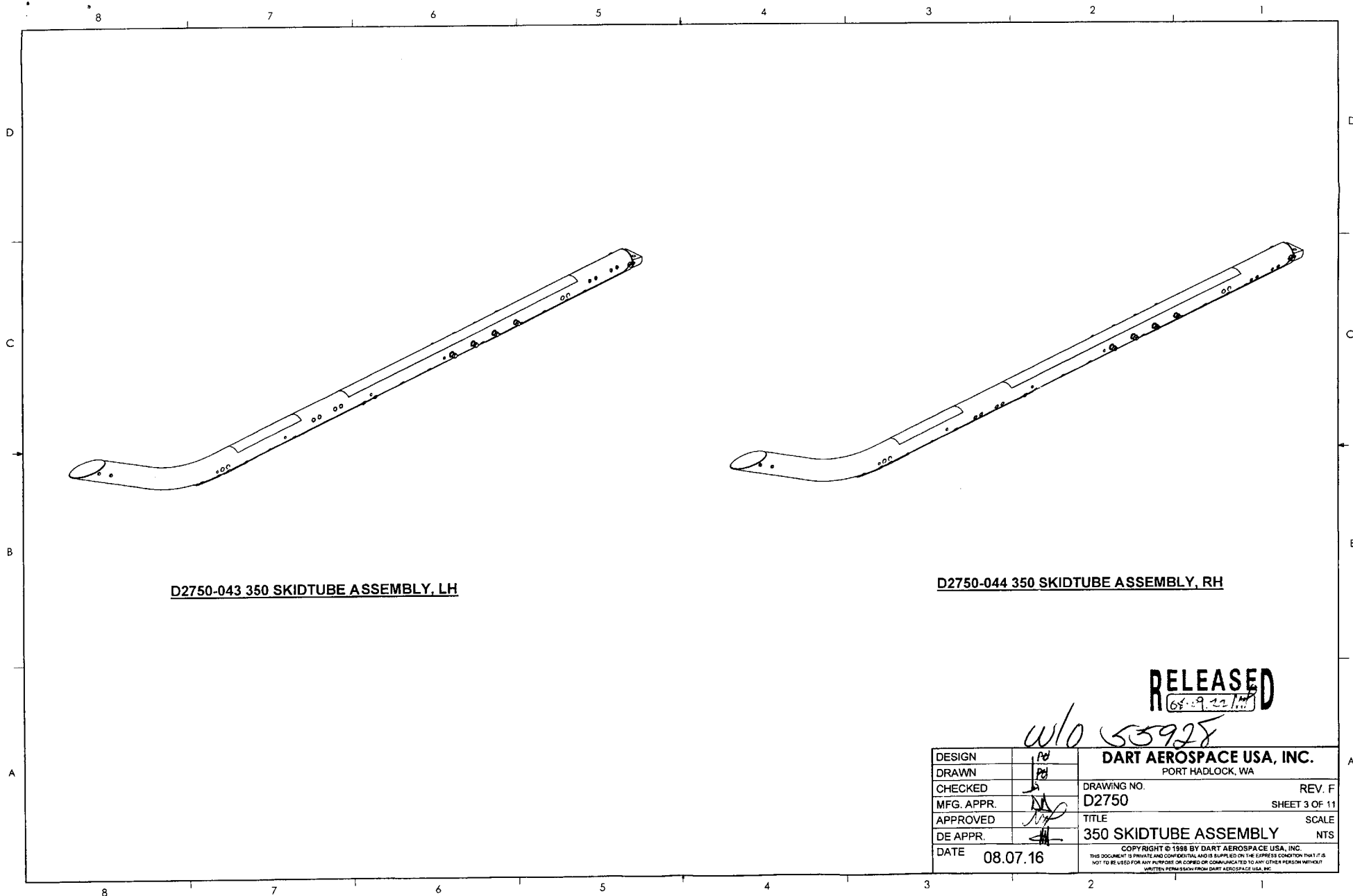
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D2750-043 350 SKIDTUBE ASSEMBLY, LH

D2750-044 350 SKIDTUBE ASSEMBLY, RH

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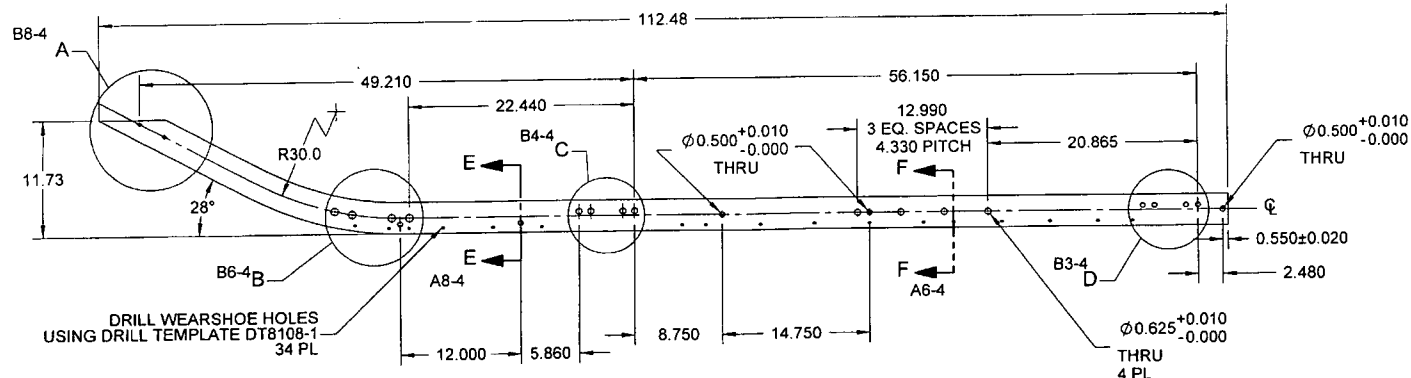
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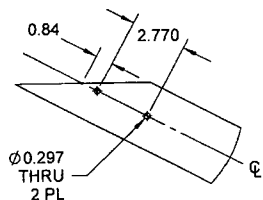
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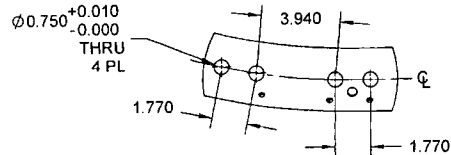
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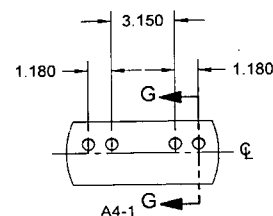
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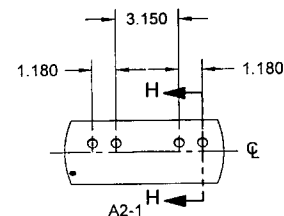
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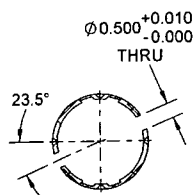
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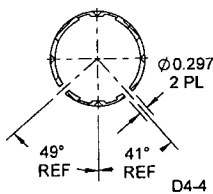
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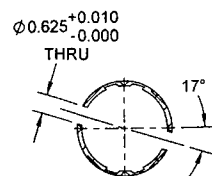
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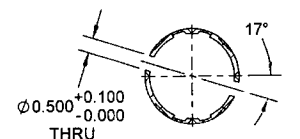
SECTION E-E
SCALE 3X, 2 PL



SECTION F-F
SCALE 3X, 17 PL



SECTION G-G
SCALE 3X, 4 PL



SECTION H-H
SCALE 3X, 4 PL

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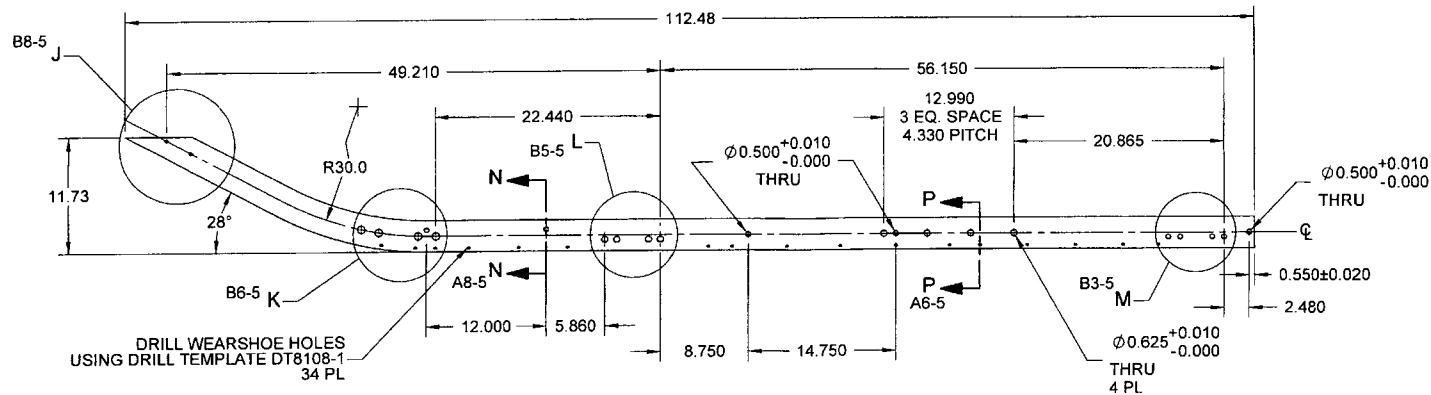
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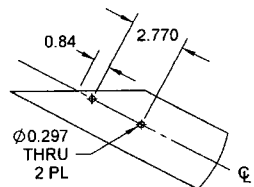
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

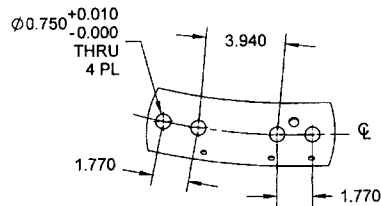
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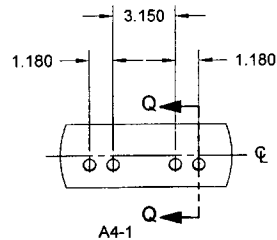
D2750-2 RH SKIDTUBE



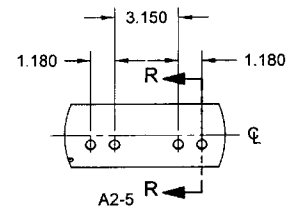
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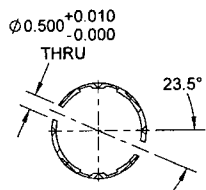
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SCALE 2X



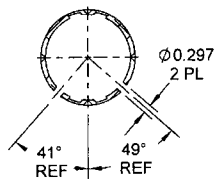
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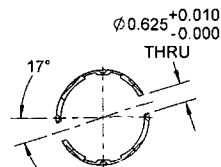
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SCALE 2X



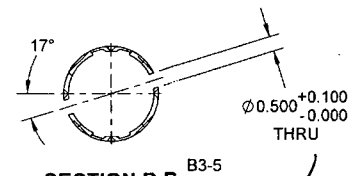
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SCALE 3X, 2 PL



SECTION P-P
SCALE 3X, 17 PL



SECTION Q-Q
SCALE 3X, 4 PL



SECTION R-R
SCALE 3X, 4 PL

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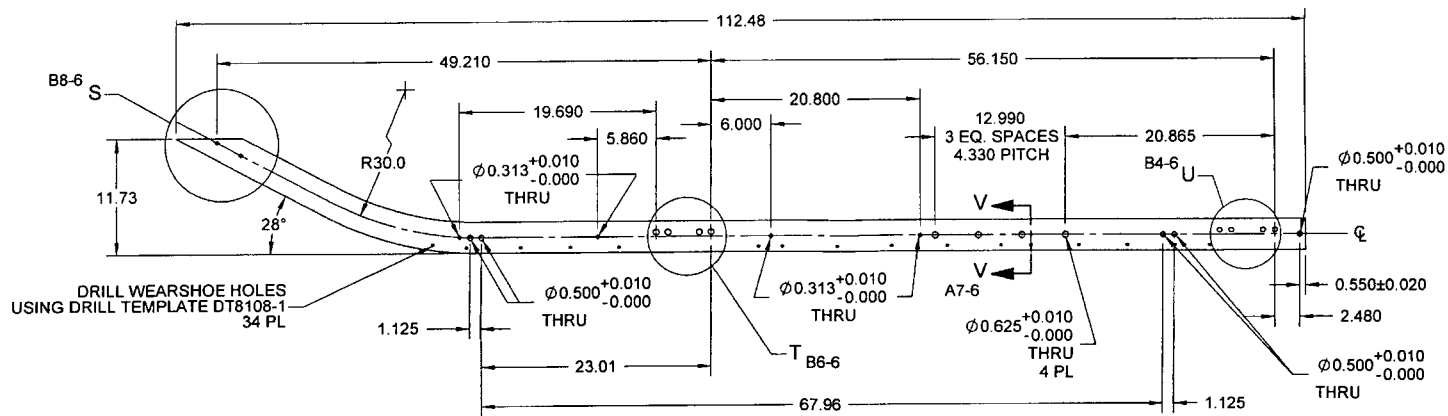
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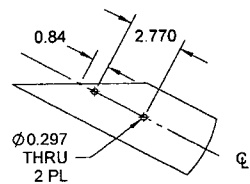
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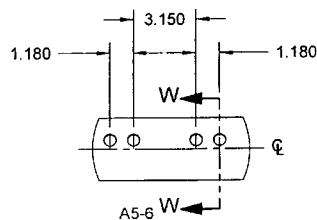
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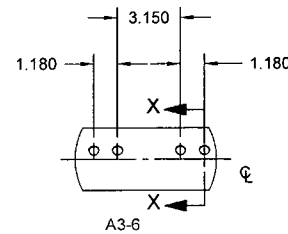
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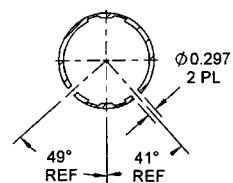
DETAIL S
D8-6
SCALE 2X



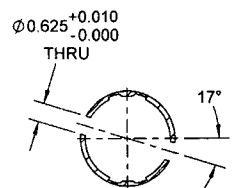
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C5-6
SCALE 2X



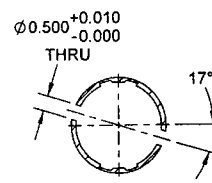
DETAIL U
D3-6
SCALE 2X



SECTION V-V
C4-6
SCALE 3X, 17 PL



SECTION W-W
B6-6
SCALE 3X, 4 PL



SECTION X-X
B4-6
SCALE 3X, 4 PL

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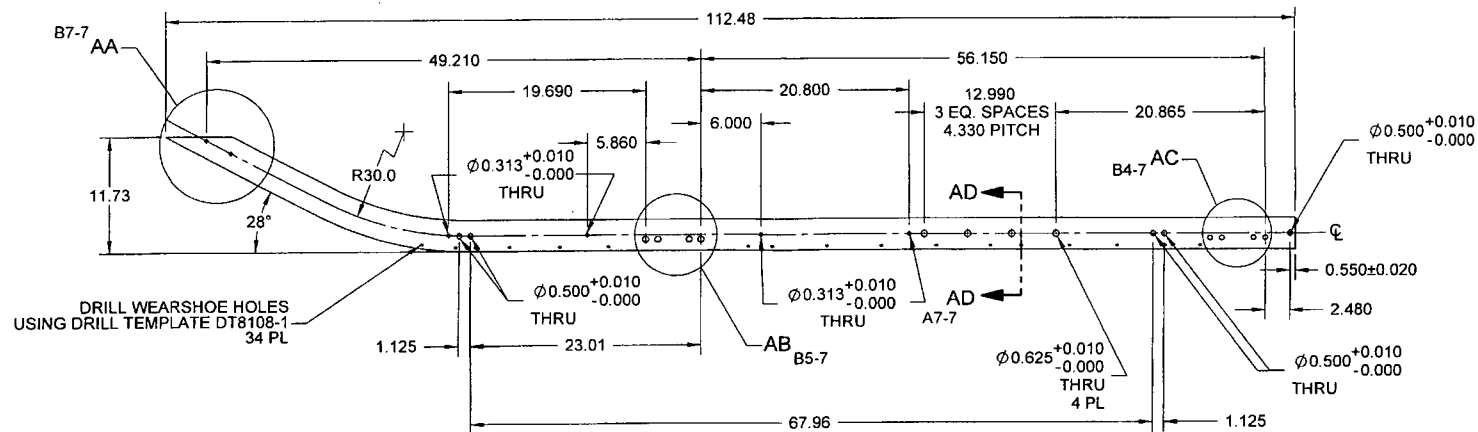
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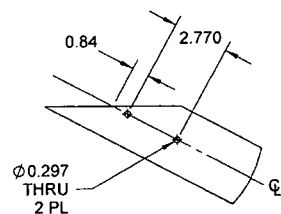
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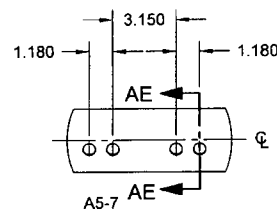
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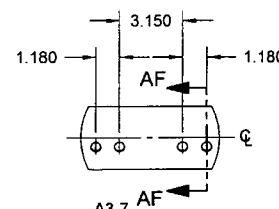
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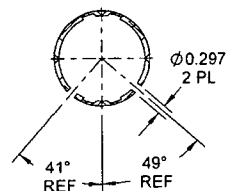
DETAIL AA
SCALE 2X



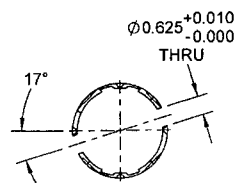
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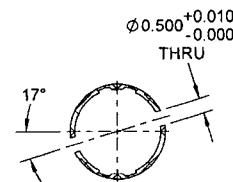
DETAIL AC
SCALE 2X



SECTION AD-AD
SCALE 3X, 17 PL



SECTION AE-AE
SCALE 3X, 4 PL



SECTION AF-AF
SCALE 3X, 4 PL

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55928

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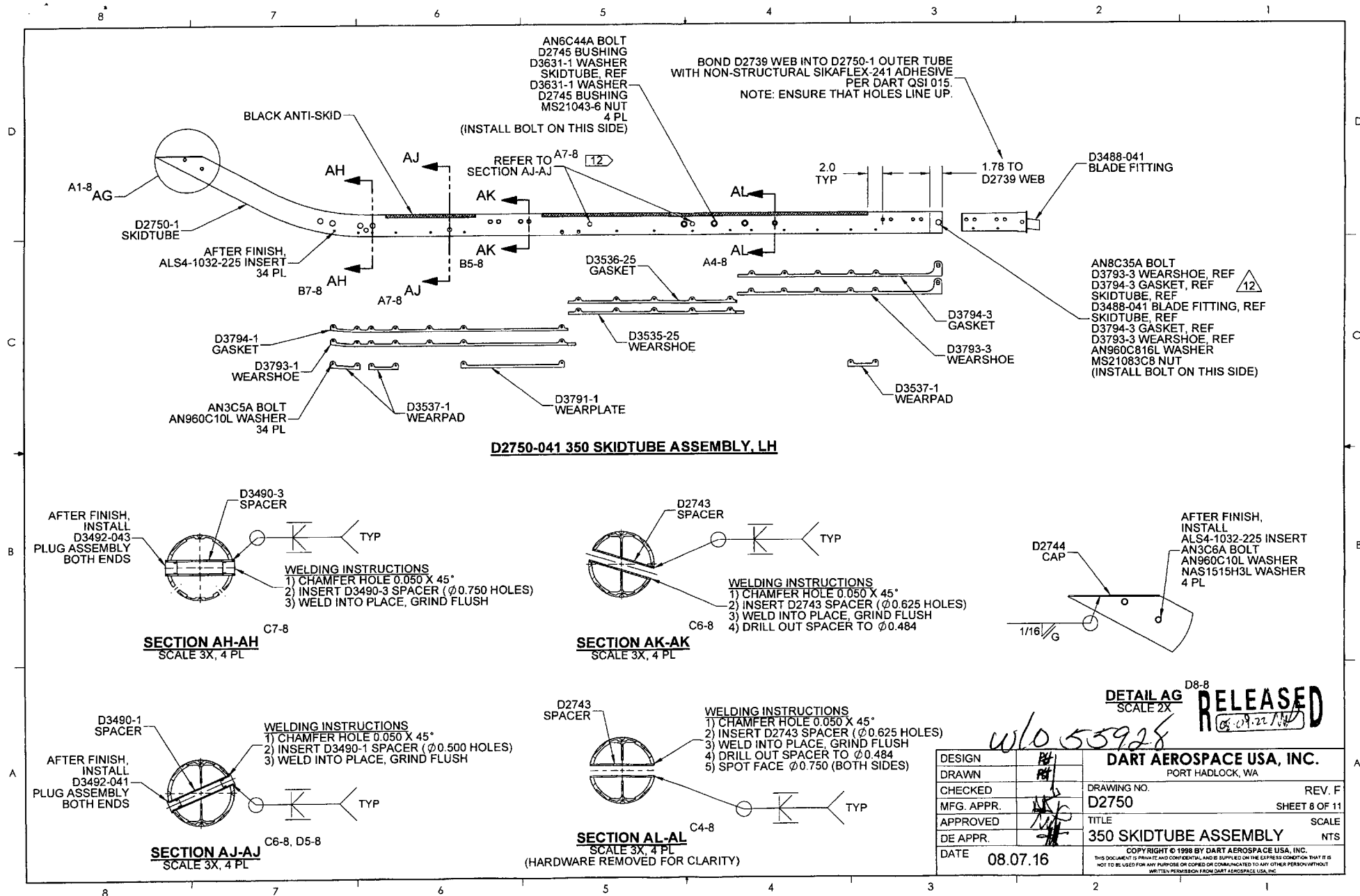
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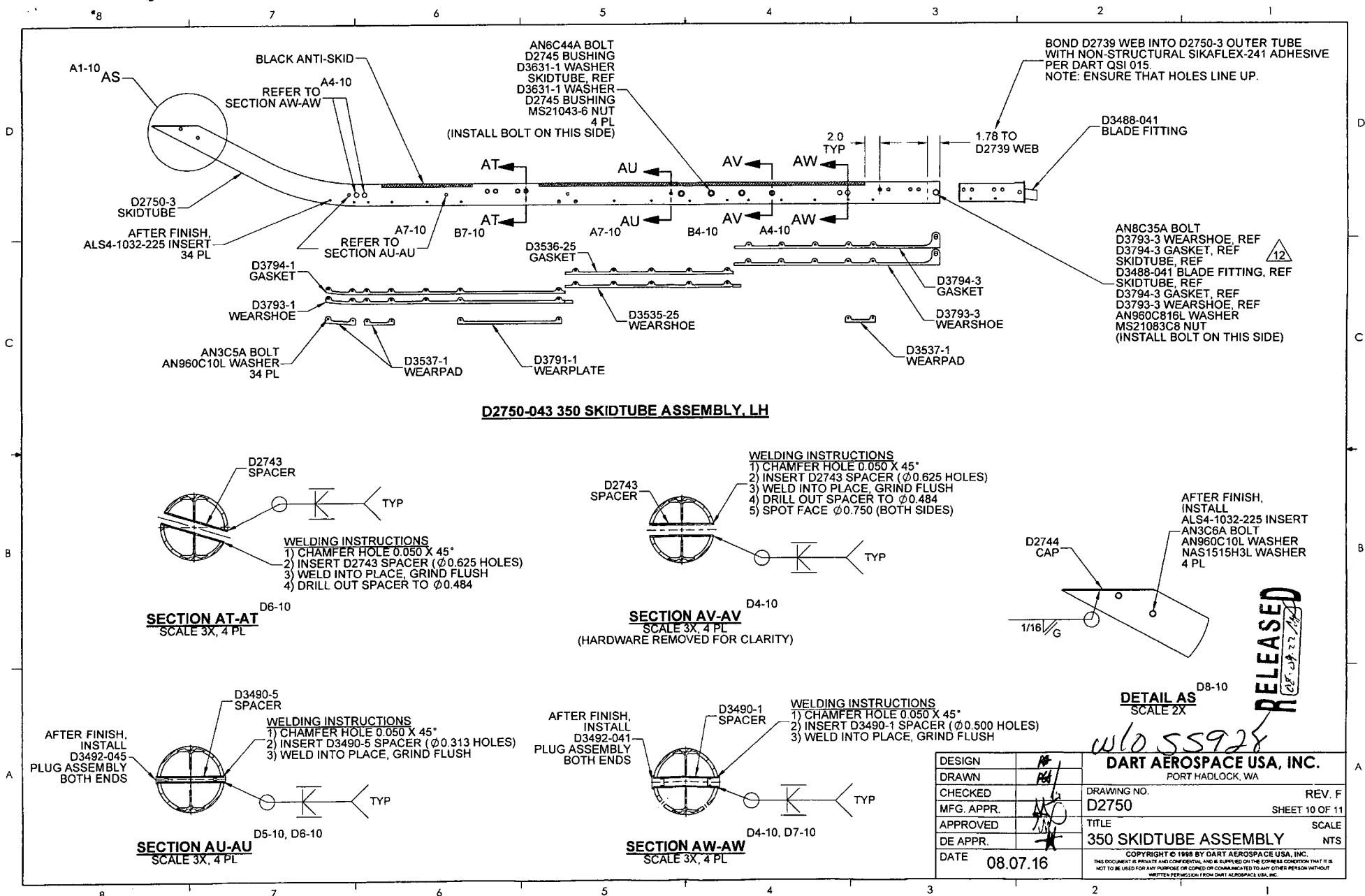
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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

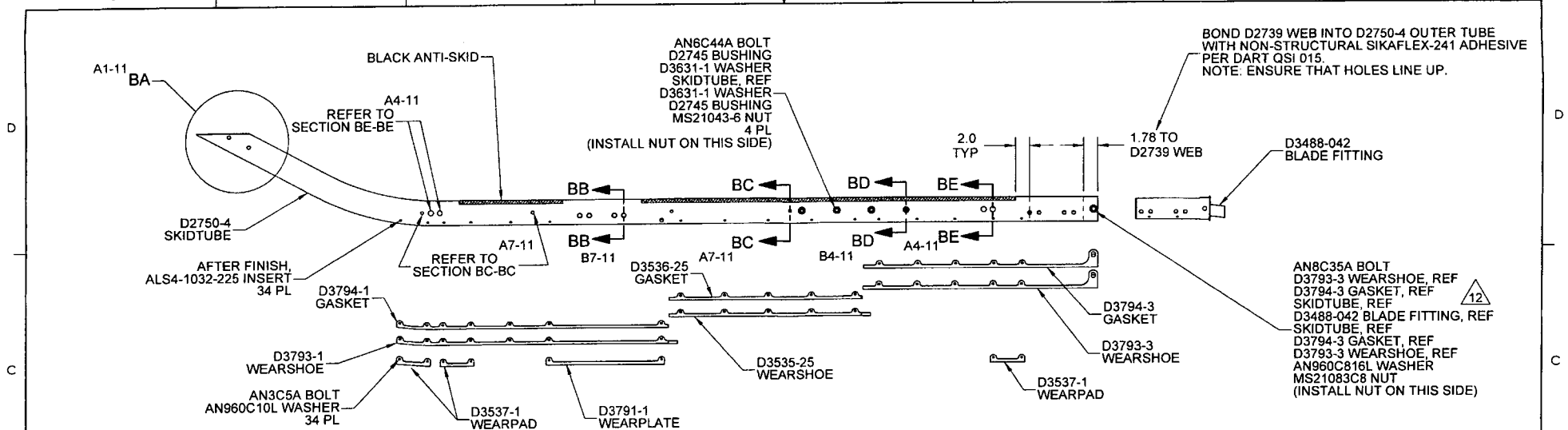
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

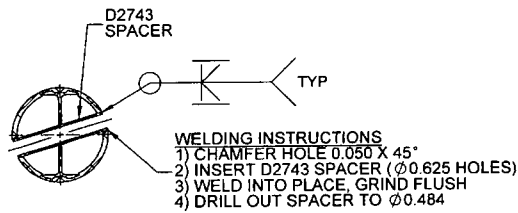
NOTE: Date & initial all entries

8 7 6 5 4 3 2 1

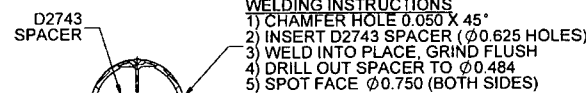


D2750-044 350 SKIDTUBE ASSEMBLY, RH

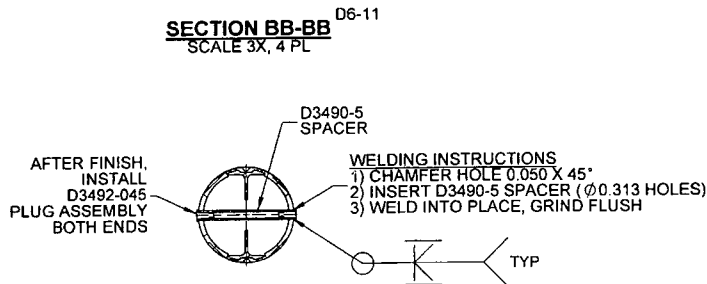
RELEASED
06-07-22 / H



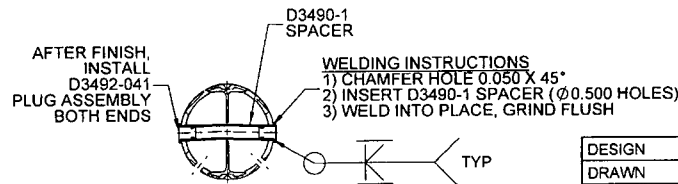
SECTION BB-BB
SCALE 3X, 4 PL



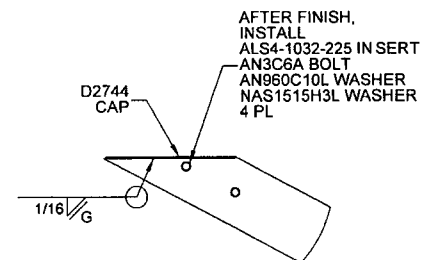
SECTION BD-BD
SCALE 3X, 4 PL
(HARDWARE REMOVED FOR CLARITY)



SECTION BC-BC
SCALE 3X, 4 PL



SECTION BE-BE
SCALE 3X, 4 PL



DETAIL BA
SCALE 2X

DESIGN	PH	DART AEROSPACE USA, INC.	
DRAWN	PH	PORT HADLOCK, WA	
CHECKED	PH	DRAWING NO. D2750	REV. F
MFG. APPR.	PH	TITLE 350 SKIDTUBE ASSEMBLY	SHEET 11 OF 11
APPROVED	PH	SCALE	NTS
DE APPR.	PH	COPYRIGHT © 1988 BY DART AEROSPACE USA, INC.	
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8 7 6 5 4 3 2 1

W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

NO. 222

AWS D17.1.2001
QUALIFICATION TEST RECORD

Name: Barclay Elliott
Job number: 54986
Part number: D350-636-012
Description: 350 skid tube
Welding Process: Tig[☒] Mig[]
Base material: Aluminium
Current: AC[☒] DC[]

TEST REQUIREMENTS AND RESULTS

Visual: pass[☒] fail[]
Penetration: pass[☒] fail[]

UNACCEPTABLE

Cracks: pass[☒] fail[]
Undercut: pass[☒] fail[]
Pin holes: pass[☒] fail[]
Overlap (cold lap): pass[☒] fail[]
Porosity (surface): pass[☒] fail[]
Coloration: pass[☒] fail[]

Qualifier Pat. Dn. Date of Test Coupon 10-01-11

Welder Barclay Elliott Date of Test Coupon 10-04-11

The above named individual is qualified in accordance with AWS D17.1.2001 to weld